

# Work Order ID 86999

Monday, July 09, 2012 10:47:33 AM

\*86999\*

Page 1

Item ID: D4327-3F

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Angle

Start Date: 7/9/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 7/10/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: *mr*

Date: 12-07-09 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4327

A

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

2024 .040

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

*1 0 Jm 12-7-9*

*1 0 Jm 12-7-9*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86999****\*86999\***

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Start Date: 7/9/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/10/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

135

QC3- Inspect Part Finish

0.00

**\*135\***

QC

Memo

0.00

Quality Control

8/21/10

CC

1 7/6 12-7-10

12 12-7-10

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Stop **\*NS2\***

Item Name: Angle

Start Date: 7/9/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/10/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Identify as per dwg & Stock Location **137**

0.00

**\*140\***

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

MLJ 12/07/10

MK  
12-07-10

# Dart Aerospace Ltd

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# Picklist Print

Monday, July 09, 2012 10:47:33 AM

Page 1

Work Order ID: 86999

Parent Item: D4327-3F

Parent Item Name: Angle

Start Date: 7/9/2012

Required Date: 7/10/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	176.1612	0.32	0.3368421			
2024-T3 .040 sheet										0.4			Jan 12-28

Location

Loc Qty

Loc Code

MAT022

176.1611626

120605

49.6627416

121197

32.498421

122136

94

122136

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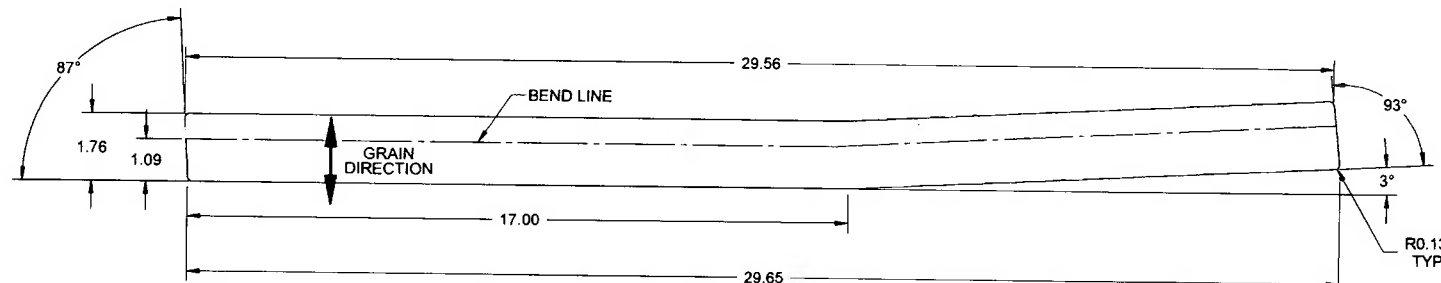
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**D4327-3 ANGLE**  
(MAKE FROM D4327-3F FLAT PATTERN)  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-7)



**D4327-3F FLAT PATTERN**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-7)

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK  
QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037  
OR ASTM B209  
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs
- 8) FORM TO SUIT DOOR PROFILE

RELEASED  
2011-04-06

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4327</b>	REV. A
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>VRD PARTS</b>	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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